Work Orde Wednesday, Aug			1								Page 1
Revision ID: Item Name:	D3454-7 Bushing		1188118 11811 8811	Accept				<b>IIIII</b> s	Setup Star Sto		
Start Date: Required Date: Reference:	9/1/2011 9/15/2011	Start Qty: 20.00 Req'd Qty: 20.00			Cust Item I Customer:	D:					
Approvals:	Process Pla	an: MF	Date:     - 09-0  Date:			ate:	<u> </u>	R	Run Star Stop		<b>1919</b>   1919
Sequence ID/ Work Center ID	)	Operation Description	1	Set Up/ Run Hours	Tool ID	.Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr		- O							
Hardinge CNC Lathe	e Small	Hardinge CNC LATHE  Memo  1-TURN AC  REV:	SMALL SPER FOLIO FA573 & D	0.00  0.00  WG D3454 ,□FOLIO □2-DEBURR AS REQU				20	Ø		-
QC Quality Control		QC2- Inspect parts off n  Memo	nachine FAI/FAIB	0.00				20	4		
120 QC Quality Control		QC8- Inspect parts - seco	ond check	0.00 0.00 <b>b</b> .a	11/09/19			20	<u></u>		

## **Dart Aerospace Ltd**

W/O:		WORK ORDER C	HANGES				
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	).	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	Δ:	Date:	1

	R	esolution:	Dispositio	n:	_ QA: N/C Clos	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)			
		Description of NC		Corrective Action Section	on B	Verification	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
				·				
		-		· ·				
				•	,			

Page 2

Item ID:

Wednesday, August 31, 2011 11:06:46 AM D3454-7

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Start Date: <

Bushing

9/1/2011

**Start Qty: 20.00** Req'd Qty: 20.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Required Date: 9/15/2011

Date: \_\_\_\_\_

SPC (Y/N):

**Tool ID** 

Date:

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

0.00

Set Up/

**Run Hours** 

130

Sequence ID/

Work Center ID

Small Fab Small Fab

Small Fab

Operation

Description

Deburr if necessary.

140



Quality Control

QC5- Inspect part completeness to step on W/O

Memo

Memo

150



Packaging

Packaging

Identify as per dwg & Stock Location 575

Memo

0.00

0.00

Sp 11-09-2

Dart Aeros	pace	Ltd
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W/O:			<del></del>	WORK ORDER	CHANGES		****			
DATE	STEP		PRO	CEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
٠										
		; ;								
Part No	):		PAR #:	Fault Category:	NCR:	Yes	No DQ	A:	Date: _	
	F	Resolution:		Disposition:	ΟΔ: Ν	NC C	losed:		Date:	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B		Verification	Approval	Approval		
DATE	STEP	Section A	Initial Action Description Sign & Chief Eng Date		Section C	Chief Eng	Approval QC inspector			
		, ;								
		, ,								

#### Work Order ID 73346

Wednesday, August 31, 2011 11:06:46 AM



Page 3

Item ID:

D3454-7

Accept



Setup Start

Stop

Stop



**Revision ID:** 

Item Name: Start Date:

Bushing

9/1/2011

**Start Qty: 20.00** 

Req'd Qty: 20.00

Operation



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

Required Date: 9/15/2011

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Sequence ID/

**Work Center ID** Description

QC21- Final Inspection - Work Order Release

Set Up/ **Run Hours** 

Tool # Plan

Code

Accept Qty

Reject Qty

Reject Insp. Number Stamp

160

Memo

0.00

0.00

Quality Control

MK 11-09-20

## **Dart Aerospace Ltd**

	•								
W/O:			WO	RK ORDER CHANGES	3				
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
						·			
Part No	•	PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	A:	_ Date: _	
	Re	esolution:	Disposition	ı:	QA: N/C CI	osed:		Date:	
NCR:		\		R NON-CONFORMAN	CE (NCF	l)			
DATE	STEP	Description of NC		Corrective Action Section		Verifi	cation	Approval	Approval
DAIL	JILI	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sect	ion C	Chief Eng	QC Inspector
,									

### **Picklist Print**

Wednesday, August 31, 2011 11:06:42 AM

Work Order ID: 73346

Parent Item:

D3454-7

Parent Item Name: Bushing



**Start Date:** 9/1/2011

Required Date: 9/15/2011

**Start Qty: 20.00** 

Required Qty: 20.00

**Comments:** 

IPP REV. A 05.11.17 New Issue

IPP Rev:B 08-04-25 chg to revB DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Primary Item Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303R0.750		Purchased	No		100	f	124.7700	0.0526	1.107368	11.	( )	

303 Round Bar 0.750

<b>Location</b>	Loc Qty	Loc Code	`
MAT028	124.77		
117328	36.97		
117798	9.8		
118400	36.4		
~118509	41.6		1 Loot no toe

Dart	<b>Aeros</b>	pace	Ltd
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		· · · · · · · · · · · · · · · · · · ·				<u></u>			
Part No	· - <u>·</u>	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	
	R	esolution:	Disposition	n:	_ QA: N/C CI	osed:		Date: _	
NCR:		1	WORK ORD	ER NON-CONFORM	ANCE (NCR	)			
DATE	CTED	Description of NC			tion B	Verifi	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date		tion C	Chief Eng	QC Inspector
,									
								<b>!</b>	

DART AEROSPACE LTD	Work Order:	73346
Description: Bushing	Part Number:	D3454-7
Inspection Dwg: D3454 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

	<u></u>	X First Arti		<del></del> 1	otype		
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Com	ments
Ø0.250	+0.005/-0.000	252			21-9		
Ø0.372	+0.000/-0.005	0.3695		·			
0.343	+0.005/-0.000	. 345					
0.060	+0.010/-0.000	063		-			
0.75	+/-0.030	750					
Measured by:		Audited by:	B.A		Prototype Ap		N/A
Date:	WY/IX	Date:	11/09/11	7		Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	06.09.01	New Issue	KJ/JLM ,	
В	07.11.23	Dimensions updated	KJ/EC/DD	N/

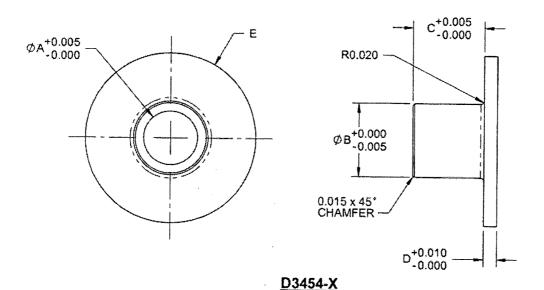
	Dart	<b>Aeros</b>	pace	Ltd
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	. oopaoo								
W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PRO	CEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		·							
Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	A:	Date:	
		esolution:							
NCR:		W	ORK ORDI	ER NON-CONFORMAN	NCE (NCF	1) _	<i></i>		*
DATE	STEP	Description of NC	Corrective Action Se			Verifi	Verification	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date		ion C	Chief Eng	QC Inspector
									1
				4,					
					<b>No.</b>		•		
1					1	- 1		!	



DESIGN R	•	DRAWN BY RF	DART AEROSPA HAWKESBURY, ONTARIO	
CHECK	ED #	APPROVED	DRAWING NO.	REV. B
DATE	05.1	12.05	TITLE BUSHING	SCALE 2:1
Α	0	5.09.02	NEW ISSUE	
В	0	5.12.05	REVISE -5/-7	

RELEASED 05.12.09



1) SPECIFICATION: D3454-X BUSHING

DASH No.

### WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)	D (in)	E (in)
-1	0.316	0.435	0.420	0.060	1.00
-3	0.316	0.435	0.400	0.060	0.75
-5	0.250	0.372	0.400	0.060	0.75
<u>-7</u>	0.250	0.372	0.343_	0.060	.0.75

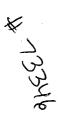


#### NOTES:

- 1) MATERIAL: AISI 303 SS ROUND BAR (REF. DART SPEC. M303R)
  2) FINISH: NONE
  3) IDENTIFY WITH P/N USING FINE POINT PERMANENT MARKER
  4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  5) ALL DIMENSIONS ARE IN INCHES
  6) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

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# **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	HANGES
DATE	STEP	PROCEDURE CHANGE	By Date Qty Approval Chief Eng / Prod Mgr QC Insp
		·	
ų k			

Part No:	PAR #:		Fault Category:	NCR: Yes No	DQA:	Date:	
	Resolution:	·	Disposition:	QA: N/C Closed	i:	Date:	

NCR: WORK ORDER NON-CONFORMANCE (NCR)								
DATE STEP	Description of NC		Corrective Action Section B		Verification	Approval	Approval	
	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector